

Work Order ID 87198

87198

Page 1

July-11-12 10:09:10 AM

Item ID: D350-604-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Rear Locker Extender

Stop

NS2

Start Date: 7/16/12 Start Qty: 1.00

1

Cust Item ID:

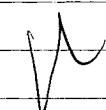
Required Date: 8/17/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2273	F								
D350-604-041	B								

100 0.00

100

DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile and create labels per PPP D350-604-041

CHG003 for D2273 rev.E (new gelcoat)

CHG004 for D2273 rev.F (new primer)

DAS
16
8-09

12/05/08

MCJ 12/08/08

110

0.00

110

PURCHASING

Purchasing

Memo

17548

0.00

Purchasing

Issue P/O:

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 122441

4 x 2600-LW Retaining washers - Ship to Delastek B 1224452

12 12-07-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 7/16/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

120

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS
16
8-69

1/20/08

Memo

0.00

Check hole locations to template. DT 8824 Check process sheet and audit.

140

140

Small Fab

Stores

Memo

0.00

INSTALL DECALS AS PER DWG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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July-11-12 10:09:10 AM

Item ID: D350-604-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Rear Locker Extender

Stop

NS2

Start Date: 7/16/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Q4

Memo

0.00

DAS

16

9-89 12/08/08

160

160

Packaging

Packaging

0.00

12/8/08

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-604-041

Location: _____

PPP Rev: _____

170

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

MJ 12/08/08

Memo

0.00

MF
12-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-11-12 10:09:10 AM

Page 1

Work Order ID: 87198

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 7/16/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF
521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6 Camlock Stud		Purchased	No			110	Each	199.0000	4	4	4	122441	sf
				<u>Location</u>			<u>Loc Qty</u>						
				ST380			199						
					120077		8						
					121556		4						
					122317		42						
					122335		145						
2600-LW Camloc Retaining Washer		Purchased	No			110	Each	319.0000	4	4	4	122452	sf
				<u>Location</u>			<u>Loc Qty</u>						
				ST380			316						
					121524		116						
					122317		200						
				ST381			1						
					121287		1						
				ST398			2						
					120648		2						
D2268 Decal		Manufactured	No			140	Each	31.0000	1	1	1	12/08/08	sf
				<u>Location</u>			<u>Loc Qty</u>						
				ST007			20						
					80010		20						
				ST009			11						
					69592		2						
					78908		9						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-11-12 10:09:10 AM

Page 2

Work Order ID: 87198

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 7/16/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

D2269
Decal

Manufactured No Each 25.0000

1

✓ JB 12/08/08

Location Loc Qty Loc Code

ST007 20

80011

80011 20

ST009 5

78920

78920 5

D350-604-041P
Rear Locker Extender

Purchased No 110 Each 0.0000

1 1

87198

MF 12-08-08

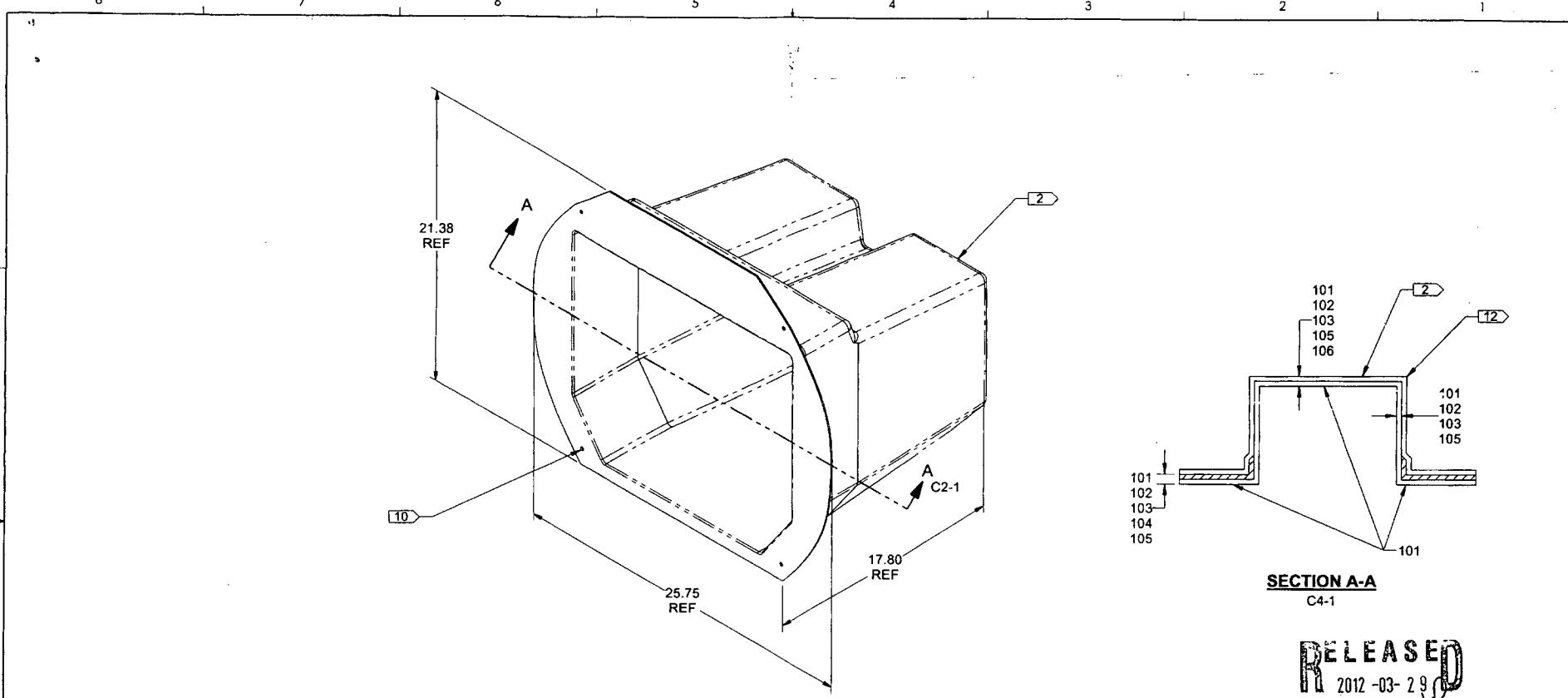
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



NOTES:

- 1) MATERIALS:
 - RESIN: DERAKANE 470-36/411/510A40
 - FIBRE: 9 oz = 9.7 oz 7781 WEAVE "S" GLASS
 - 18 oz = 18.0 oz ROVING "E" GLASS
- 2) FINISH: FINISH THIS SURFACE WITH DUPONT GREY PRIMER LE 3404-S/LE 1175-S F
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 7.75 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 9) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/ACCUM
- 10) TRIM & DRILL PER DT8020. OPEN HOLES TO Ø0.257 (4 PLACES)
- 11) CONSTRUCTION:
 - 101-WHITE GLOSS GELCOAT # GEL 2330PAWK745 TO MIN THICKNESS OF 0.020
 - 102-9 oz ALL OVER
 - 103-18 oz ALL OVER
 - 104-18 oz REINFORCE FRONT FLANGE EXTENDING 2" ON SIDES
 - 105-9 oz ALL OVER
 - 106-PEEL PLY
- 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

10/17/98
D2273 REAR LOCKER EXTENDER

RELEASED
2012-03-29

F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DC</i>	DRAWING NO. D2273 REV. F	
CHECKED	<i>AS</i>	SHEET 1 OF 1	
MFG. APPR.	<i>BL</i>	TITLE 350 REAR LOCKER EXTENDER NTS	
APPROVED	<i>MM</i>	SCALE	
DE APPR.	<i>MM</i>	DATE 12.02.27	

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NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

NCR: Yes / No

DQA: Date: ✓

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			
	<input type="checkbox"/> Other										

Solve Composites

29 Distribution Way

Suite 101

Plattsburgh, NY 12901

Phone: 518-324-3838

Fax: 518324-5530

Packing List

Bill Dart Aerospace

To: 1270 Aderdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace

To: 1270 Aderdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 13406

Shipment Date: 08/03/12

Ship Via: Fedex Freight

Order Number: 11936

Order Date: 07/26/12

Customer Code: DART

Phone: (613) 632-9577

PO Number: 17548

Terms: Net 30 Days

	Quantity								Job
	<u>Open</u>	<u>Shipped</u>	<u>Back Ord</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>		<u>Revision</u>	<u>Number</u>
	5	4	1		EA	D350-604-041P D350-604-041P Rear Locker Extender		F	11936-01

Packing Clerk's Initials
Solve Composites



Received In Good Order By
Dart Aerospace



Certificate of Conformance

Solve Composites

29 Distribution Way

Plattsburgh, New York, 12901

USA

Dart Aerospace Order Number: 17548

Part Number: D2273

Quantity: 1

Drawing Number: D2273, DT8020

Serial Number (s): 0003

Date: August 7, 2012

Non-Conformances: None

This is to certify that the parts identified above conform to all applicable drawings and/or specifications as evidenced by reports on file, and that all other purchase order and quality requirements have been met.

A handwritten signature in black ink, appearing to read "Jerry Reyell".

Jerry Reyell

Project Manager

Solve Composites

